

Date: Monday, 11/08/2008 2:45:33 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB
Job Number	: 41127	Part Number	: D2739
Estimate Number	: 10498	Drawing Number	: D2739 REV D
P.O. Number	:	Project Number	: N/A
This Issue	: 11/08/2008	Drawing Revision	: D
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 20/08/2008
Previous Run	: 40723	Qty:	10 Um: Each
Written By	:		12 DP
Checked & Approved By	: <u>JL 08.8.11</u>		8-8-14
Comment	Est Rev: C 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM Est Rev: E 07-07-28 As per Rev D JLM Verified By:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
 Extrusion 'I Beam' thin
 Pick:
 Qty Part Number Description Batch
 1 D2600-5 Web B 29955 (4) B-38589 (8)

2.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
 1-Cut D2600-5 to length as per Dwg D2739.
 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
 3-Use uni-bit to open holes to finish size as per Dwg D2739.
 4-Bevel Fwd end of extrusion and Deburr holes and ends.
 5-Dburr

> 10 8-8-14

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

DE 08-08-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				5/1			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8-8-15 JB

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8-8-15 JB

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location: LG

8-8-15 JB

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/19 JB

Job Completion



W 8-8-15

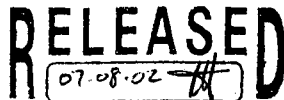
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

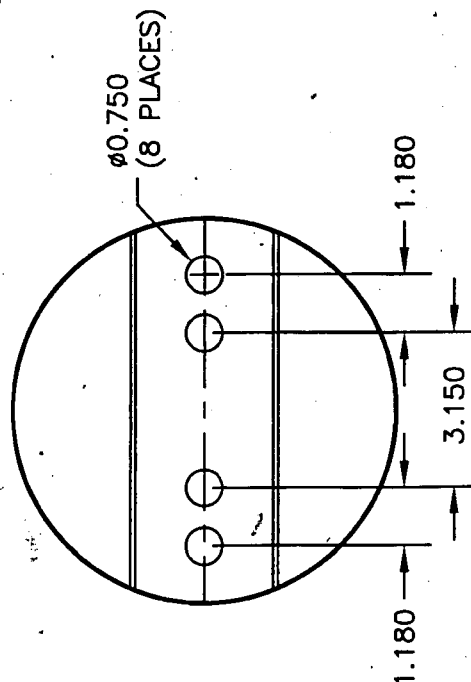
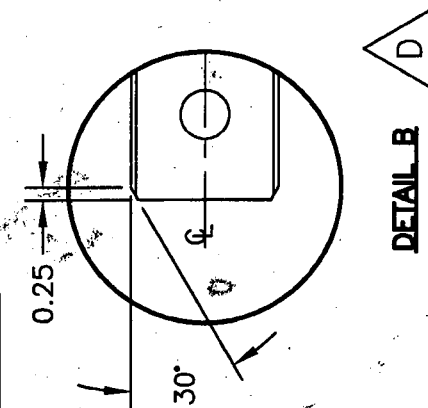
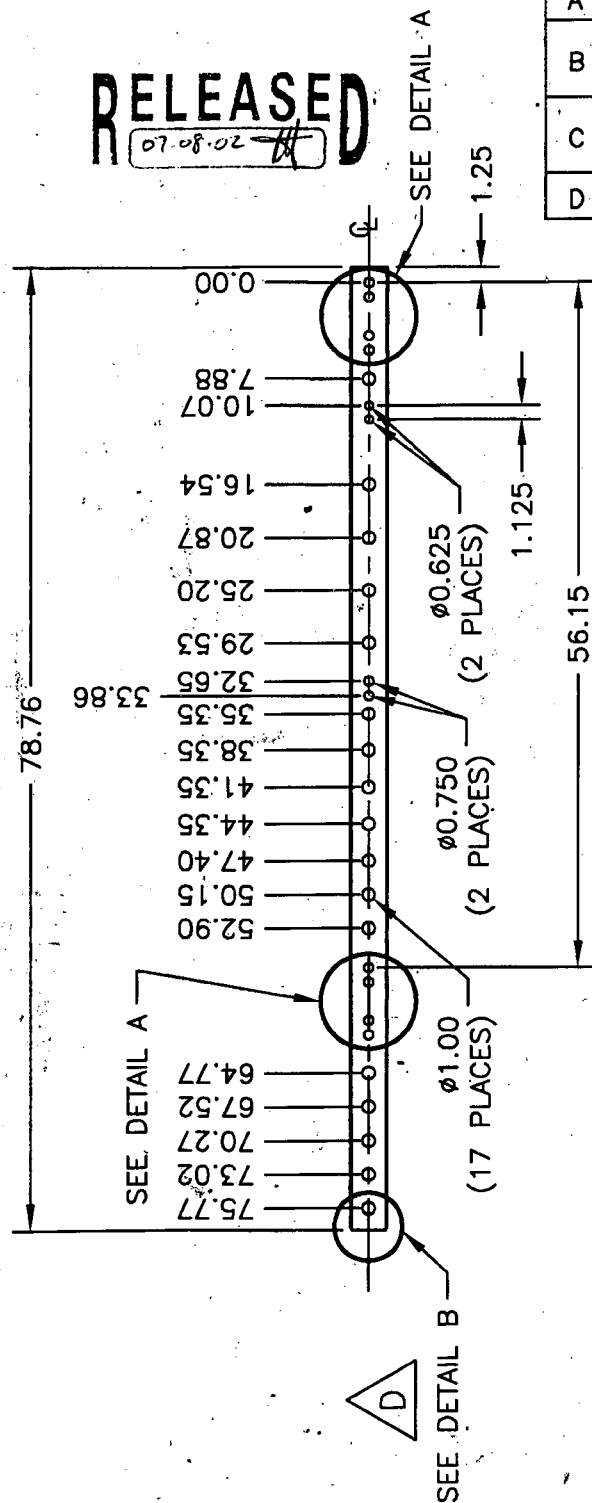
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



A	98.04.16	NEW ISSUE
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS
D	07.05.29	ADD BEVEL TO FWD END; ADD DETAIL B



DETAIL A

NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT C

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NO. 4127

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